

ABSTRACT OF THE DISCLOSURE

The invention an arc welding solid wire whose surface comprises copper plated film, wherein the elastic limit ratio (elastic limit/tensile strength) of the wire finally produced is controlled in the range between 50 and 88 % by installing three to eight elastic limit ratio control vertical rollers and three to eight elastic limit ratio control transverse rollers which have a ratio D/d equal to 40 to 60, following coil control vertical and transverse rollers after final drawing.